

Date:
User:

Thursday, 6/21/2007 2:28:41 PM
Kim Johnston

split GREEN

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number :	33043	Part Number :	D2574		
Estimate Number :	10534	Drawing Number :	D2574 REV E		
P.O. Number :	NIA	Project Number :	N/A		
This Issue :	6/21/2007	Drawing Revision :	E		
Prsht Rev. :	NC	Material :	NIA		
First Issue :	NIA	Due Date :	7/11/2007	Qty:	12 Um: Each
Previous Run :	32168	Type :	MACHINED PARTS		
Written By :	<i>[Signature]</i>				
Checked & Approved By :	<i>[Signature]</i>				
Comment :	Est Rev: I As Per RevE 06-01-27 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2574
Ensure that grain is along 5.00" length
Batch No: *1325350*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. *SA* Double check by: *JF*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

SA / JMK 01.01.16

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

JMK / SA 01.01.16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA / JMK 01.01.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:28:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 33043

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/07/16

(14)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

J.S.

07-07-16 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN SANDTEX (Ref: 4.3.5.1) as per QSI 005 4.3

M 18144

M.A. / BR 07-07-16

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

F.R.

07/07/16

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/7/17 SP

(17)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.17

Job Completion



W 07-07-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33043
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.439	0.440	0.439	0.438		
B	1.745	1.755		1.751	1.750	1.750	1.749		
C	3.495	3.505		3.500	3.501	3.500	3.499		
D	1.745	1.755		1.750	1.750	1.750	1.749		
E	7.990	8.010		8.001	8.002	8.000	7.999		
F	0.490	0.510		.496	0.504	0.504	0.502		
G	0.257	0.262	DT8683	.257	0.258	0.258	0.258		
H	0.375	0.380	DT8684	.376	0.377	0.377	0.377		
I	0.490	0.510		.501	0.500	0.500	0.500		
J	1.174	1.184		1.175	1.178	1.178	1.178		
K	0.558	0.578		.571	0.571	0.570	0.568		
L	1.174	1.184		1.179	1.178	1.178	1.178		
M	1.365	1.375		1.370	1.369	1.369	1.369		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.121	4.121	4.122		
P	0.115	0.135		.124	0.124	0.125	0.124		
Q	0.115	0.135		.135	0.135	0.135	0.135		
R	0.240	0.260		.250	0.250	0.251	0.251		
S	0.115	0.135		.130	0.132	0.134	0.134		
T	0.178	0.198		.188	0.188	0.188	0.188		
U	3.210	3.250		3.232	3.231	3.231	3.230		
V	0.230	0.250		.241	0.240	0.240	0.241		
W	0.115	0.135		.135	0.131	0.134	0.134		
X	0.307	0.312		.310	0.311	0.310	0.310		
Y	0.760	0.765		.762	0.766	0.766	0.766		
Z	0.352	0.372		.370	0.369	0.369	0.367		
AA	0.470	0.530		.500	0.500	0.500	0.500		
AB	0.615	0.635		.629	0.630	0.629	0.629		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.249	0.246	0.246	0.247		
AE	1.500	1.520		1.511	1.511	1.511	1.509		
AF	0.115	0.135		.135	0.135	0.135	0.135		
AG	0.240	0.280		.270	0.276	0.276	0.270		
AH	0.240	0.260		.250	0.250	0.249	0.251		
AI	2.000	2.020		2.002	2.002	2.003	2.001		
AJ	0.023	0.043		.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <i>SA/9mk</i>	Audited by: <i>J.F.</i>
Date: <i>07/07/13</i>	Date: <i>07/07/116</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JA</i>

21

DART AEROSPACE LTD	Work Order: 33043
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	438	438	438	438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.501	3.500	3.501	3.500		
D	1.745	1.755		1.749	1.750	1.745	1.750		
E	7.990	8.010		8.004	8.003	8.003	8.003		
F	0.490	0.510		.500	.499	.498	.500		
G	0.257	0.262	DT8683	0.258	0.258	.258	.258		
H	0.375	0.380	DT8684	0.377	0.377	.377	.377		
I	0.490	0.510		0.500	0.500	.499	.503		
J	1.174	1.184		1.178	1.178	1.179	1.179		
K	0.558	0.578		0.569	0.568	.567	.572		
L	1.174	1.184		1.178	1.178	1.178	1.179		
M	1.365	1.375		1.369	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.502	2.501		
O	4.119	4.129		4.121	4.121	4.122	4.123		
P	0.115	0.135		0.123	0.124	.123	.124		
Q	0.115	0.135		0.135	0.135	.135	.135		
R	0.240	0.260		0.249	0.251	.252	.251		
S	0.115	0.135		0.129	0.129	.122	.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.232	3.232		
V	0.230	0.250		0.239	0.239	.238	.240		
W	0.115	0.135		.128	.130	.129	.130		
X	0.307	0.312							
Y	0.760	0.765							
Z	0.352	0.372		.368	.368	.367	.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		.630	.632	.633	.634		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.247	.247	.250		
AE	1.500	1.520		1.511	1.511	1.511	1.512		
AF	0.115	0.135		0.135	0.135	.135	.135		
AG	0.240	0.280		0.270	0.265	.266	.269		
AH	0.240	0.260		0.250	0.249	.251	.249		
AI	2.000	2.020		2.003	2.003	2.003	2.003		
AJ	0.023	0.043		.033					
Accept/Reject									

Measured by: <i>Paul J. Smith</i>
Date: 07.07.10

Audited by: <i>J.F.</i>
Date: 07/07/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	33043
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.438	.439	.439	.439		
B	1.745	1.755		1.750	1.749	1.749	1.749		
C	3.495	3.505		3.500	3.501	3.500	3.500		
D	1.745	1.755		1.750	1.749	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.003	8.003		
F	0.490	0.510		.497	.496	.497	.496		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.326		
I	0.490	0.510		.498	.502	.503	.503		
J	1.174	1.184		1.177	1.179	1.179	1.179		
K	0.558	0.578		.571	.572	.573	.572		
L	1.174	1.184		1.175	1.177	1.175	1.175		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.499	2.498	2.499	2.499		
O	4.119	4.129		4.123	4.127	4.127	4.124		
P	0.115	0.135		.123	.124	.124	.123		
Q	0.115	0.135		.135	.135	.135	.133		
R	0.240	0.260		.249	.251	.250	.250		
S	0.115	0.135		.123	.123	.123	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		.241	.242	.242	.24		
W	0.115	0.135		.123	.126	.127	.127		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.762	.763	.763	.763		
Z	0.352	0.372		.364	.364	.363	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.630	.628	.624		
AC	0.053	0.073		.063	.063	.063	.023		
AD	0.240	0.260		.250	.248	.251	.250		
AE	1.500	1.520		1.511	1.511	1.511	1.511		
AF	0.115	0.135		.135	.135	.133	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.253	.250	.250		
AI	2.000	2.020		2.001	2.002	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SA
Date:	07.07.15

Audited by:	J.F.
Date:	07/07/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 33043
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

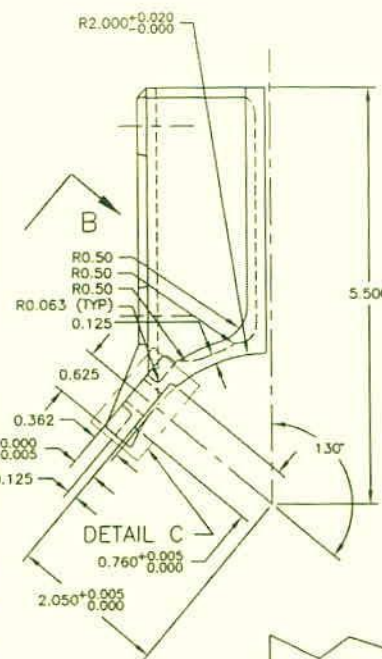
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682						
B	1.745	1.755							
C	3.495	3.505							
D	1.745	1.755							
E	7.990	8.010							
F	0.490	0.510							
G	0.257	0.262	DT8683						
H	0.375	0.380	DT8684						
I	0.490	0.510							
J	1.174	1.184							
K	0.558	0.578							
L	1.174	1.184							
M	1.365	1.375							
N	2.495	2.505							
O	4.119	4.129							
P	0.115	0.135							
Q	0.115	0.135							
R	0.240	0.260							
S	0.115	0.135							
T	0.178	0.198							
U	3.210	3.250							
V	0.230	0.250							
W	0.115	0.135							
X	0.307	0.312							
Y	0.760	0.765							
Z	0.352	0.372							
AA	0.470	0.530							
AB	0.615	0.635							
AC	0.053	0.073							
AD	0.240	0.260							
AE	1.500	1.520		1.511	1.511				
AF	0.115	0.135							
AG	0.240	0.280							
AH	0.240	0.260							
AI	2.000	2.020		2.001	2.002				
AJ	0.023	0.043							
Accept/Reject									

Measured by: <i>SD</i>
Date: 01.01.16

Audited by: <i>J.F.</i>
Date: 07/07/16

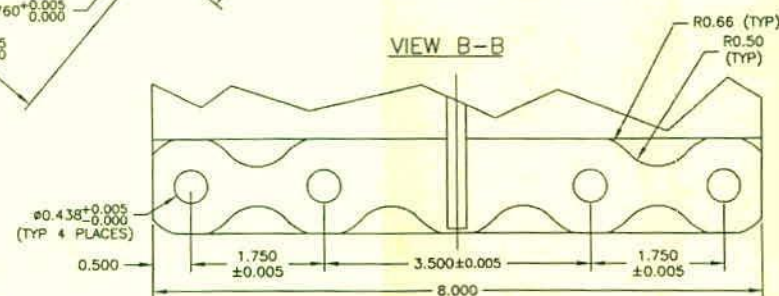
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JA</i>

05.2.06 ~~11~~

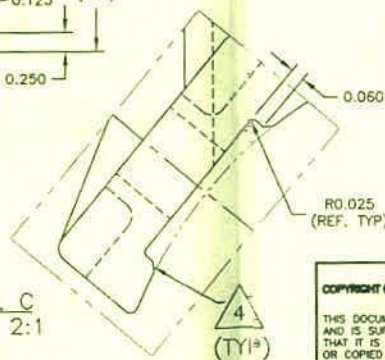





MATERIAL: 7073-T7351 (Q0-A-250/12)
(REF DART SPEC. D8102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
| 1 | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
| 2 | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
| 3 | CHAMFER 0.063 x 45° ALL AROUND |
| 4 | CHAMFER 0.033 x 45° (SEE DETAIL C) |



DETAIL C
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		DRAWN BY
DS		PH
CHECKED 		APPROVED 
DATE		TITLE
05.07.13		INNER AFT SADDLE
		 DART AEROSPACE LTD. <small>HARRISBURY, ONTARIO, CANADA</small>
		REV. _____ SHEET 1 OF _____ SCALE _____

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WITHOUT NOTICE
WORK ORDER
NO. 33043

DAVID AEROSPACE LTD

Work Order:

33043

Part Name: Saddle, Aft Inboard

Part Number:

D2574

Rev: Dwg: D2574 Rev. E

Page 1 of 1

Dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below.

			Recorded Actual Dimensions					
1	Min	Max	Go/No Go Gauge	1	2	3	4	Date
1	0.44		0.44	.435	.435			
2	1.758			1.750	1.750			
3	3.506			3.500	3.500			
4	1.758			1.750	1.750			
5	3.014			3.003	3.003			
6	2.514			.496	.495			
7	0.268			.258	.258			
8	0.336			.316	.316			
9	0.514			.501	.503			
10	1.134			1.121	1.121			
11	0.574			.573	.573			
12	1.134			1.121	1.121			
13	1.374			1.370	1.370			
14	2.528			2.498	2.498			
15	4.129			4.124	4.124			
16	0.135			.124	.124			
17	0.135			.135	.135			
18	0.250			.250	.257			
19	0.135			.124	.124			
20	0.194			.188	.188			
21	3.250			3.232	3.232			
22	0.250			2.92	2.92			
23	0.135			.128	.127			
24	0.314			.310	.310			
25	0.763			.763	.763			
26	1.374			.364	.363			
27	0.530			.500	.500			
28	0.635			.627	.625			
29	0.063			.063	.063			
30	0.260			.251	.251			
31	1.534			1.511	1.511			
32	0.135			.135	.135			
33	0.260			.260	.260			
34	0.260			.251	.251			
35	2.004			2.001	2.002			
36	0.034			.033	.033			

Accepted/Rejected

Date: 07.07.16

Audited by: J.F.
Date: 07.07.16

Date	Change	Revised by	Approved
03.07.15	NEW ISSUE	RF	
03.07.15	Re format. Add: Rev. D	KJ	
03.07.15	Re format. Add: DT8682, DT8683, DT8684	KJ	
03.07.15	Added dimension A1	KJ/RF	
03.07.15	Added dimension A2	KJ/JLM	

